

Date: Thursday, 28/05/2009 9:11:13 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 BEARPAW
Job Number : 48225A	
Estimate Number : 12480	
P.O. Number :	Part Number : D35291
This Issue : 28/05/2009 S.O. No. :	Drawing Number : D3529 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 44704A	Material :
Written By :	Due Date : 12/06/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JUD0905-27</u>	
Comment : Est Rev:A New Issue 06-06-28 JLM	
Est Rev:B New Manufacturing Method 08-11-27	Verified By:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.3283 sf(s)/Unit Total : 10.6260 sf(s)

110721 X2

108762 X2

Material: Black UHMW 1"(MUHMWB10)

Batch: 110520X2 B 9-6-8

111354 X2

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch Number

09-06-08

3.0	WATER JET	FLOW WATER JET
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A B9-6-8

Comment: FLOW WATER JET
 CUT BLANK AS PER FILE D3529-1BLANK

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

8

09/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 48225A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(8)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ATP 09/06/20

6.0

QC8

SECOND CHECK



(8)

Comment: SECOND CHECK

M.A 09/06/22

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11/09/2025

07/8/23

(8)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48225A
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

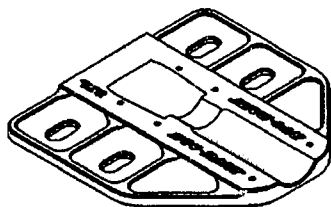
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.50	✓			
B	0.07 x 45°	+/-0.030 x 0.5°	0.07 x 45°	✓			
C	R0.25	+/-0.030	0.250	✓			
D	0.250	+/-0.010	0.251	✓			
E	0.625	+/-0.010	0.625	✓			
F	0.950	+/-0.010	0.943	✓			
G	1.63	+/-0.030	1.621	✓			
H	12.14	+/-0.030	12.147	✓			
I							
J	5.70	+/-0.030	5.70	✓			
K	0.375	+/-0.010	0.377	✓			
L	0.525	+/-0.010	0.527	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.13 x 45°	✓			
N	R0.50	+/-0.030	0.50	✓			
O	12.76	+/-0.030	12.767	✓			
P	3.38	+/-0.030	3.377	✓			
Q	3.75	+/-0.030	3.753	✓			
R	5.187	+/-0.010	5.187	✓			
S	5.25	+/-0.030	5.25	✓			
T	7.13	+/-0.030	7.130	✓			
U	Ø0.260	+0.006/-0.001	0.260	✓			
V	0.30	+/-0.030	0.310	✓			
W	0.93	+/-0.030	0.92				
X	1.30	+/-0.030	1.300	✓			

Measured by: DJP	Audited by: H.A	Prototype Approval: N/A
Date: 09/06/20	Date: 09/06/22	Date: N/A

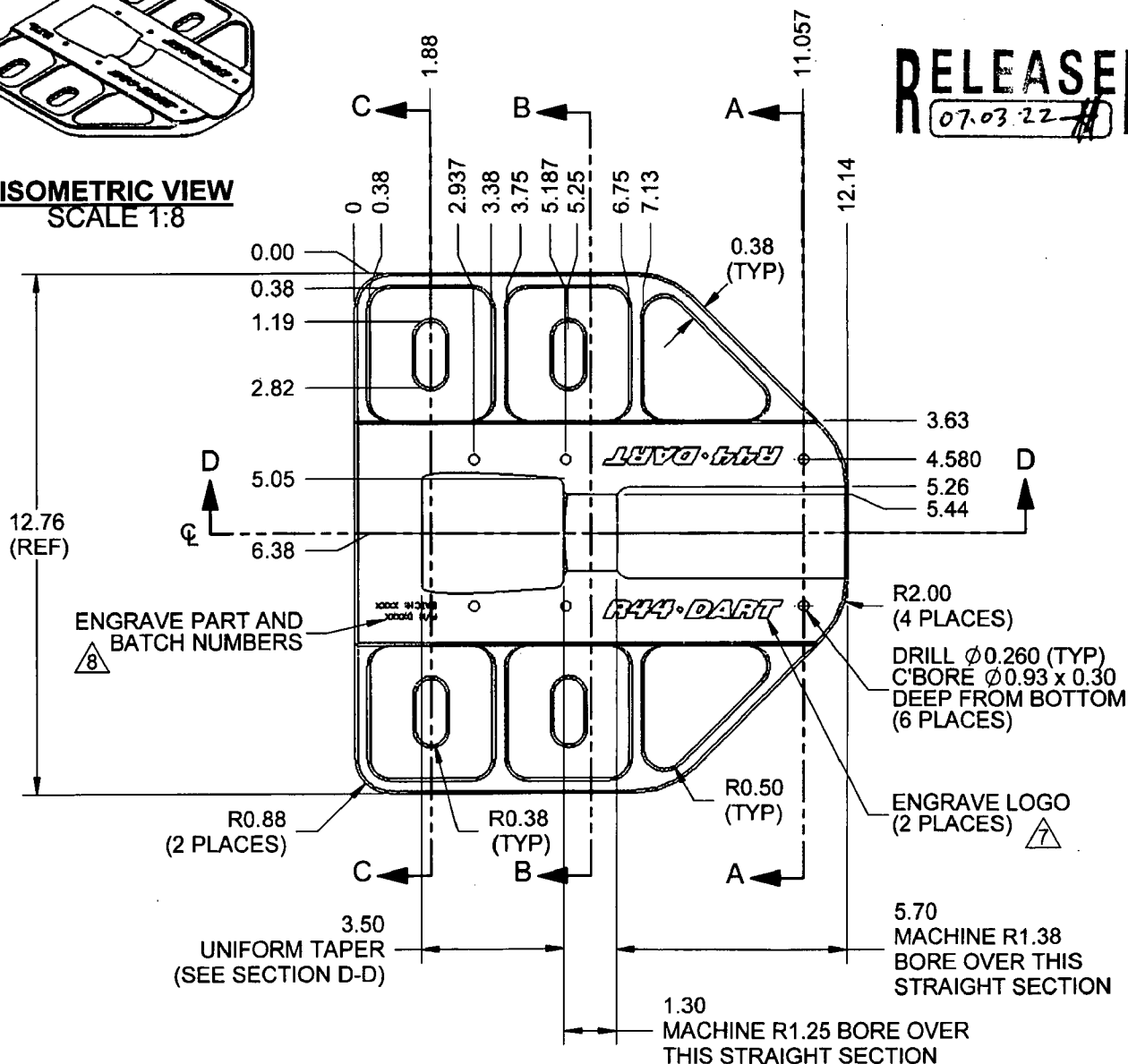
Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **48225A**

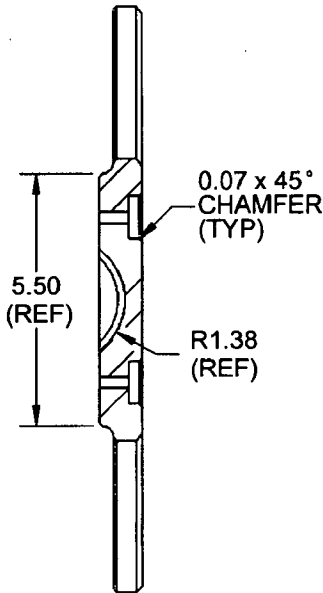
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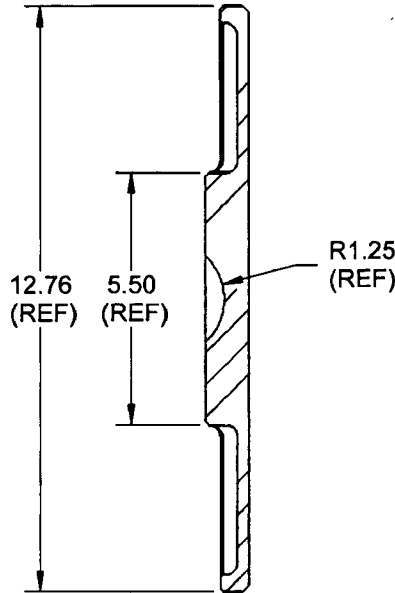


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DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

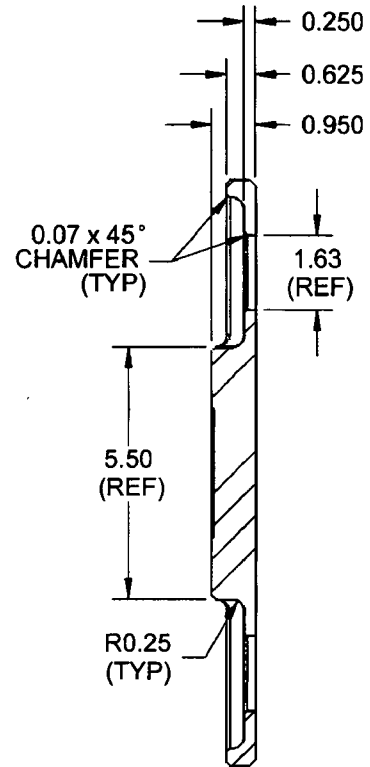
RELEASED
07.03.22



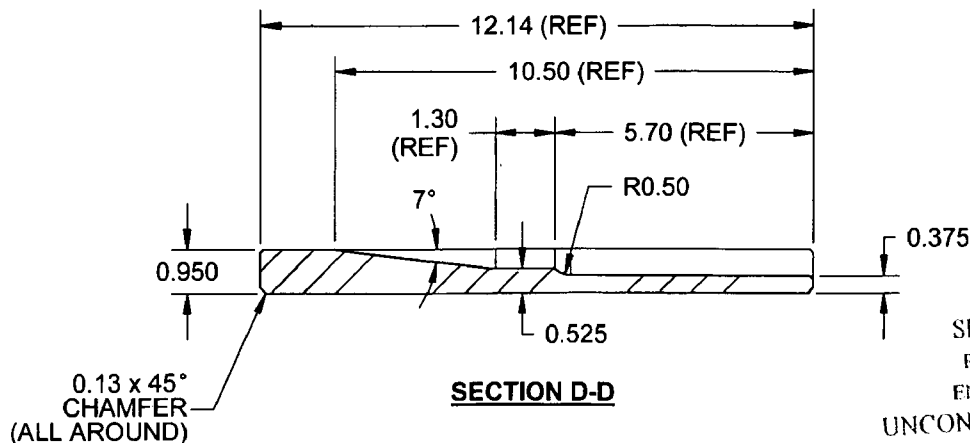
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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